

DART AEROSPACE LTD		Work Order:	23861
Description: Clevis		Part Number:	D3348-1
Dwg: D3348 Rev. <i>K B [signature] 05.06</i>		Qty:	13
Ref:		Page 1 of 1	



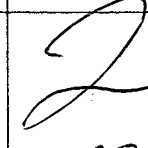

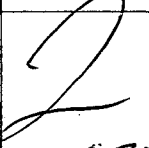
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AL	05/07/25	15
2	PG	Issue P/O: <u>2008396</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3348 Possible Supplier: Industrial Laser Material release note is required	AL	05/07/25	15
3	RG	Receive and Inspect for transit damage Enure material release note is attached	CL	05/07/29	15
4	QC6	Inspect dimensions as per Dwg D3348	L	05.08.15	15
5	GA	Deburr	SAD	05/08/22	15
6	GB	Form as per Dwg D3348	SB	05/08/30	15
7	QC5	Inspect work to Step 6	L	05.08.30	13
8	ST	Identify and Stock in WS cell	L	05.08.30	13
9	AC	Cost / part: <u>5.32</u>	SAC	05.08.31	13
10	DC	Close W/O <u>5.67</u> Inspect Level 21	[signature]	05.08.31	13

PTO

Rev	Date	Change	Revised By	Approved
A	05.02.09	New issue	KJ/JLM	[signature]

RELEASED
[signature] 05.02.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/08/30	6	2 were scrap out of Tolerance +0.35" under		Scrap & destroy	 05-08-30	 05-08-30	 05-08-30	 05-08-30

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05.08.30

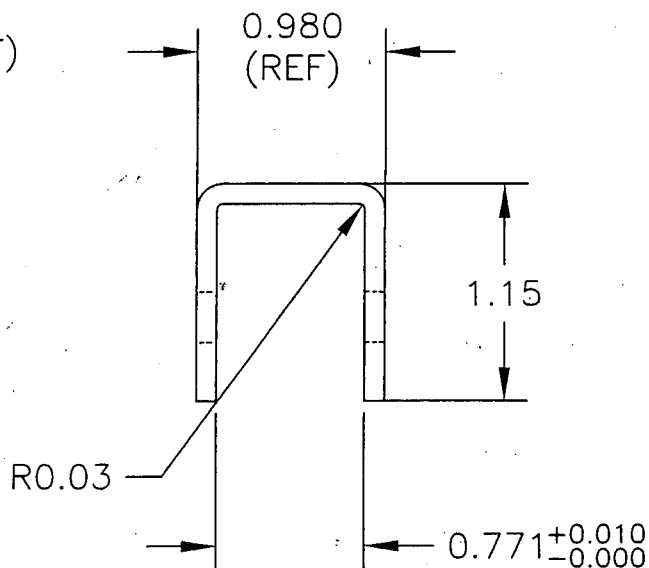
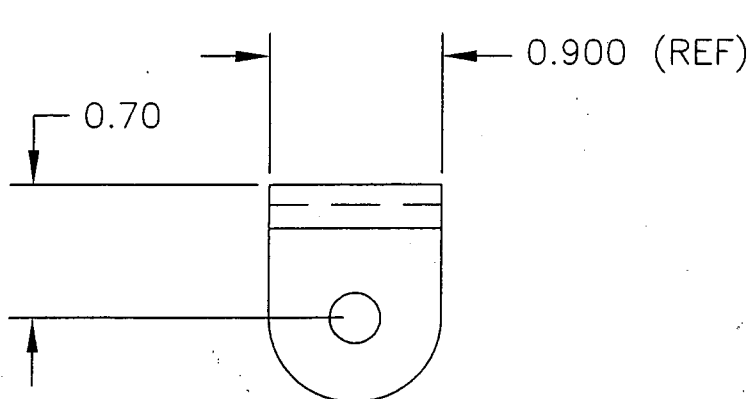
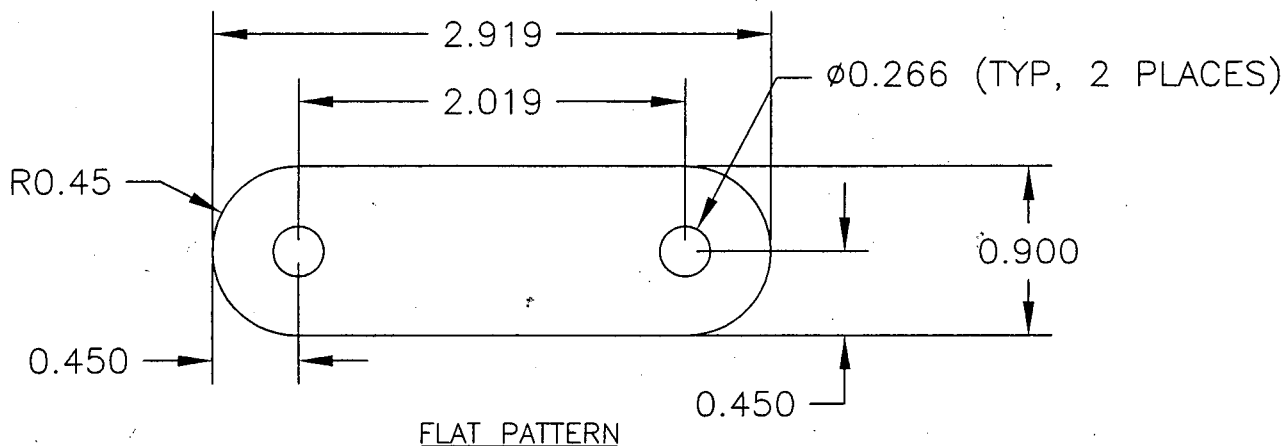
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3348	REV. B SHEET 1 OF 1
DATE 05.03.04		TITLE CLEVIS	SCALE 1:1
A	04.11.11	NEW ISSUE	
B	05.03.04	INSIDE RADIUS WAS R0.13, NOW R0.03	

RELEASED
05.03.05



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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

BENDING DETAIL

D3348-1 CLEVIS NO. 23861

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21,38W/44W/50W/60W/70W SERIES STEEL 12 GAUGE (0.105 THICK)
(REF DART SPEC. M1010-S12GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 22, 2005
07:41 am

Work Order No : 0023861
Project Name : D3348-1
Project For : WK532
Work Order Type : Main
Main WO Number :
House Part Number : D3348-1
Description : Clevis
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 07-21-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



New Zealand Steel Limited
 Greymouth, South Island
 P.O. Box 100, Greymouth, New Zealand
 Telephone: (03) 325 8888 / 325 8111 Australia
 (03) 325 8888 / 325 8888 New Zealand
 Fax: (03) 325 8888

TEST CERTIFICATE

Ref: 4217083

CUSTOMER WILKINSON		P41006ME003		SPECIFICATION ASTM A1011 CS Type 1		CERTIFICATE No. T3101993																
CUSTOMER ORK 00-314-398				PRODUCT HOT ROLLED PICKLED & OILED		PAGE 1 of 1																
MILL ORK 453758				DIMENSIONS 0.104" x 48" x Coil 12 GA M.S.		DATE 27 December 2004																
PACK NUMBER	HEAT No.	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTM A1011)						LENGTH (Feet)
		C	Si	Mn	P	S	Cr	Mo	Cu	Nb	Al	Ni	B	N	CE	BEND 180°	YIELD	T.S.	WELDON GL=	HARDNESS		
HP-942195-98	631407	5	TR	10	15	19	12	18	18	1	7	1	1			Good					955	
HP-942196-98	631407	5	TR	10	15	19	12	18	18	1	7	1	1			Good					955	
HP-942197-98	631405	5	TR	10	14	19	12	18	17	2	6	1	1			Good					955	
HP-942198-98	631405	5	TR	10	14	19	12	18	17	2	6	1	1			Good					955	
HP-942200-98	631407	5	TR	10	15	19	12	18	18	1	7	1	1			Good					955	
HP-942201-98	631405	5	TR	10	14	19	12	18	17	2	6	1	1			Good					955	
HP-942202-98	631405	5	TR	10	14	19	12	18	17	2	6	1	1			Good					955	
HP-942203-98	631405	5	TR	10	14	19	12	18	17	2	6	1	1			Good					955	
HP-942204-98	631405	5	TR	10	14	19	12	18	17	2	6	1	1			Good					955	
HP-942205-98	631405	5	TR	10	14	19	12	18	17	2	6	1	1			Good					955	
HP-942206-98	631405	5	TR	10	14	19	12	18	17	2	6	1	1			Good					955	

ATTN: LINDA LACELLE

Ref: P.O.# 2008396

P/N D3348-1

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (R)	IMPACT TEST	(C)=5mm x 5mm	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=250mm (C)=80mm	(A)=0 (C)=15	(A)=10mm x 10mm	(D)=2.5mm x 10mm	(A)=C+1/6
(B)=LOWER YIELD STRESS	(B)=50mm (D)=6.65 x 10	(B)=2 (D)=0.0025	(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+0.0008(G+H+M+N)(D+E)/15

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Moya*
 CC METALURGIST